Work Order ID 109055

November 08, 13 7:05:52 AM

D4855-1 B109055 REVA

109055

Item ID: D4855-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Antenna Bracket (Replaces P/N G13013-3)

Start Date: 11/08/13 **Start Qty:** 10.00 *10* **Cust Item ID:**

Required Date: 11/11/13 **Req'd Qty:** 10.00 *10* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** u **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4855	A								
100	Cut blanks as per folio	0.00							
100						10	0		13-11-08
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	CUT BLANK AT 3.000"								
110		0.00							
110	HAAS CNC VERTICAL MACHINING.#1					10	0		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FB200 DWG REV: A FOLIO REV: AA								
	2- deburr and break all sharp edges								

13/11/09

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120			ok 13/11/09			10	0		
QC	**Memo**	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130			F.K. 13/11/10			10	0		
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						10	NB 13-11-12		
HandFinish	**Memo**	0.00							
Hand Finishing									

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Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00				10	0	13-11-12	DAS 34 9-89
150									
QC	**Memo**	0.00							
Quality Control									
160	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum M12639	0.00				10	0	13-11-12	DAS 34 9-89
160									
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 8:30 OVEN TEMPERATURE: 320° FINISH TIME: 9:00								
170	QC3- Inspect Part Finish	0.00							
170									
QC	**Memo**	0.00				(10)			
Quality Control									

DAS 16 9-89 13/11/12

Work Order ID 109055

November-08-13 7:05:52 AM

109055

Item ID: D4855-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Antenna Bracket (Replaces P/N G13013-3)
Start Date: 11/08/13 **Start Qty:** 10.00 *10* **Cust Item ID:**
Required Date: 11/11/13 **Req'd Qty:** 10.00 *10* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location (9x)ST125 14PPP109054	0.00				10x	DAS 28 9-89	13-11-12	
180 Packaging Packaging	Memo	0.00							
190	QC21- Final Inspection - Work Order Release	0.00					13/11/13		
190 QC Quality Control	Memo	0.00							

MLE
13-11-12

Picklist Print

November-08-13 7:05:51 AM

Work Order ID: 109055

Parent Item: D4855-1 **Start Date:** 11/08/13 **Required Date:** 11/11/13

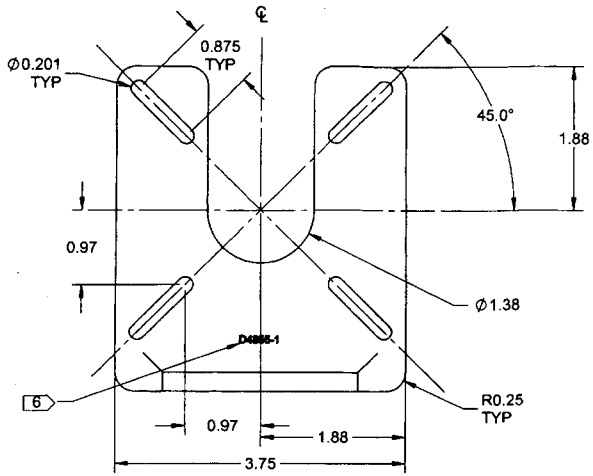
Parent Item Name: Antenna Bracket (Replaces P/N G13013-3) **Start Qty:** 10.00 **Required Qty:** 10.00

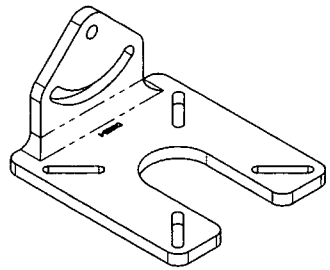
Comments: IPP REV: A NEW ISSUE JFS 13/06/26 VERIFY BY: DD

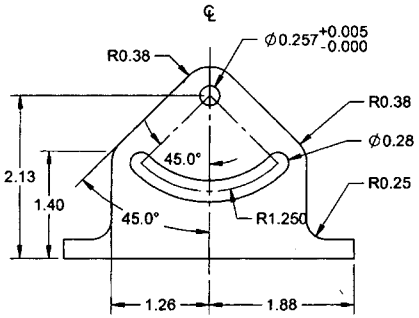
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B4.500X4.500 6061-T6 AluminumBar 4.500" X 4.500"		Purchased	No			100	f	7.5000	**0.25**	2.604 $^{3}_{1}$		13-11-08	

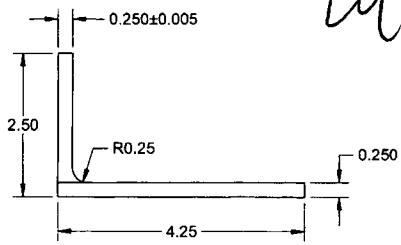
Location	Loc Qty	Loc Code
MAT004	7.5	
M126351	7.5	

2.604 $^{3}_{1}$









w/o 109085
a

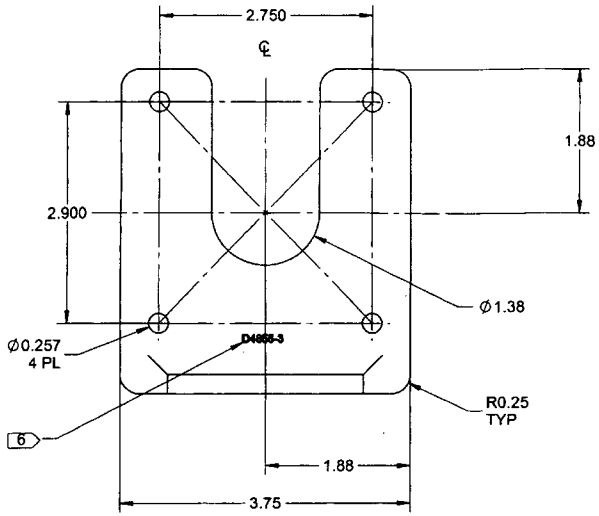
RELEASED
2013 -07- 16

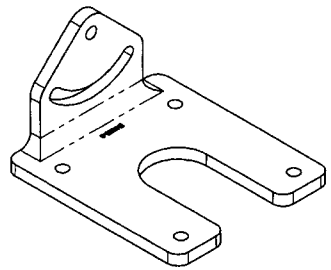
NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
OR
2024-T3/T3510/T3511 ALUMINUM ANGLE
PER AMS-QQ-A-200/3 OR AMS 4152, 4164 & 4165
REF DART SPEC M2024T3A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RADIUS OF 0.015±0.005
7) WEIGHT: 0.14 lbs
8) REPACES GENEVA P/N G13013-3

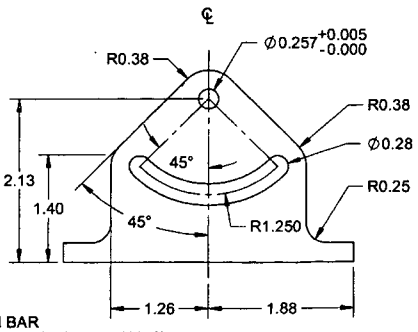
D4855-1 ANTENNA BRACKET

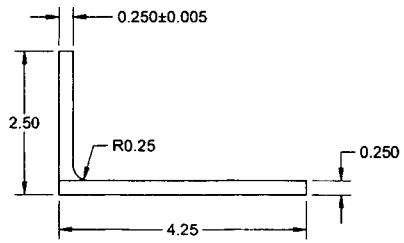
REV	DESCRIPTION	BY	DATE
A	NEW ISSUE		13.05.15

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4855 REV. A
MFG. APPR.		SHEET 1 OF 2
APPROVED		TITLE ANTENNA BRACKET
DE APPR.		SCALE NTS
DATE	13.05.15	









RELEASED
2013 -07- 16

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
OR
2024-T3/T3510/T3511 ALUMINUM ANGLE
PER AMS-QQ-A-200/3 OR AMS 4152, 4164 & 4165
REF DART SPEC M2024T3A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010 ±0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015 ±0.005
7) WEIGHT: 0.15 lbs

D4855-3 ANTENNA BRACKET

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4855 REV. A
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE ANTENNA BRACKET SCALE NTS
DE APPR.		
DATE 13.05.15		

DART AEROSPACE LTD	Work Order:	109055
Description: ANTENNA BRACKET	Part Number:	D4855-1
Inspection Dwg: D4855 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.201	$\pm^{.005}_{.001}$	.201	✓		Vern	ML-06
.875	±.010	.875	✓		"	
Ø1.38	±.030	1.380	✓		"	
R.25	±.030	R.250	✓		R-G	
1.88	±.030	1.875	✓		Vern	ML-06
.97	±.030	.974	✓		"	
3.75	±.030	3.750	✓		"	
Ø.257	$\pm^{.005}_{.000}$	Ø.259	✓		"	
R.38	±.030	R.374	✓		R-G	
2.13	±.030	2.126	✓		Vern	ML-06
1.40	±.030	1.400	✓		"	
45.0°	±½°	45°	✓		G-Square	
1.26	±.030	1.259	✓		Vern	ML-06
1.88	±.030	1.878	✓		"	
R1.250	±.010	R1.248	✓		"	
R.250	±.030	R.250	✓		R-G	
Ø.28	±.030	.280	✓		Vern	ML-06
R.38	±.030	R.375	✓		"	
.250	±.005	.246	✓		"	
2.50	±.030	2.500	✓		"	
R.25	±.030	R.250	✓		R-G	
4.25	±.030	4.250	✓		Vern	ML-06
.250	±.010	.247	✓		"	

Measured by:	[signature]
Date:	13/11/09

Audited by:	F.K.
Date:	13/11/10

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15